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Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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D3562-042
Job Sheet 191045



Part No: D3562-042

Job Qty: 2 pcs

Part Name: Step Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 3/27/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV G IPP Rev:A New Issue 06-11-09 JLM IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C
ECN1048 07-12-18 DD verified by: EC IPP Rev:D 08-07-28 add chemical conversion coat DD ver:EC IPP
REV:E 13.06.03 PER DWG REV.F DD VERF:JLM IPP REV:F 16.06.23 AS PER DWG REV.G DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	2 pcs	3/27/19		0.00	2.83	Large Fab - 1		SLA
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 5	2 pcs	3/27/19		0.00	0.00	Large Fab - 9		APR 17 2019
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
120	Handfinish - 1-1 Chemical-B4B	2 pcs	3/27/19		0.00	0.50	QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
	Handfinish - 1 - 1 - B4B						Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		

Plex 2/20/19 3:53 PM dart.white.jesse

				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R.19/04/25
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130	QC 7	2	3/27/19	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 6
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
140	Large Fab - Steps - 2 - B4B	2	3/27/19	0.00 4.50	Large Fab - 1 - B4B
		pcs			Large Fab - 10 - B4B
					Large Fab - 2 - B4B

					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	DAS
					Large Fab - 5 - B4B	43
					Large Fab - 6 - B4B	9-89
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					QC 5 - 10	
					QC 5 - 12	
150 QC 5	2 pcs	3/27/19	0.00 0.00		QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	DAS
					QC 5 - 24	24
					QC 5 - 3	9-89
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
160 Large Fab - Steps - 2 - B4B	2 pcs	3/27/19	0.00 2.83		Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	DAS
					Large Fab - 5 - B4B	43
					Large Fab - 6 - B4B	9-89
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					QC 10 - 10	
					QC 10 - 18	
170 QC 10	2 pcs	3/27/19	0.00 0.00		QC 10 - 24	
					QC 10 - 43	DAS
					QC 10 - 50	24
					QC 10 - 58	9-89
					QC 10 - 9	
					QC 5 - 10	
					QC 5 - 12	
180 QC 5	2 pcs	3/27/19	0.00 0.00		QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	DAS
					QC 5 - 3	24
					QC 5 - 42	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					Handfinish - 1 - 1 - B4B	
190 Handfinish - 1-2- Chemical-	2	3/27/19	0.00 0.50			

B4B

pcs

Handfinish - 1 - 2 - B4B
 Handfinish - 1 - 3 - B4B
 Handfinish - 1 - 4 - B4B
 Handfinish - 1 - 5 - B4B
 Handfinish - 1 - 6 - B4B
 Handfinish - 1 - 7 - B4B
 Handfinish - 1 - 8 - B4B
 Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 - B4B

DR19/65/02

Handfinish - 1 - 11 - B4B

Handfinish - 1 - 12 - B4B

Handfinish - 1 - 13 - B4B

Handfinish - 1 - 14 - B4B

Handfinish - 1 - 15 - B4B

Handfinish - 1 - 16 - B4B

Handfinish - 1 - 17 - B4B

Handfinish - 1 - 18 - B4B

Handfinish - 1 - 19 - B4B

Handfinish - 1 - 20 - B4B

Handfinish - 1 - 21 - B4B

Handfinish - 1 - 22 - B4B

200 Powdercoat - 1 White Gl(A)-
 B4B

2
pcs

3/27/19

0.00 0.67

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

BR 19-5-6

210 Handfinish - 3-1- WingWalk-
 B4B

2
pcs

3/27/19

0.00 0.50

Handfinish - 3 - 1 - B4B

Handfinish - 3 - 2 - B4B

Handfinish - 3 - 3 - B4B

Handfinish - 3 - 4 - B4B

Handfinish - 3 - 5 - B4B

22 14-5-6

215 QC 3

2
pcs

3/27/19

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 26

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 6

QC 3 - 68

220 QC	2 pcs	3/27/19	0.00 0.00	QC 3 - 9	
230 Packaging 3-1 - Stock - B4B	2 pcs	3/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
240 QC 21 - SA	2 pcs	3/27/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Fabricate per Dwg) 1-Cut D2622 extrusion as per Dwg D3562

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

140 - (Small Fab) 1- Transfer drill Rivet holes as per dwg D3562.

150 - (QC5- Inspect part completeness to step on W/O)

160 - Weld per dwg A/R Aluminum rod Batch: 1130123 1-Weld end caps as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - Chemical Conversion Coat per QSI005 4.1)

200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)START TIME: _____

210 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

215 - QC3- Inspect Part Finish)

230 - (Identify as per dwg & Stock Location: _____)

240 - (QC21- Final Inspection - Work Order Release)

Fg dock

AUG 01 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 pcs (1 ea)	100-Large Fab - Steps - 1	✓ S130307
D2734	Step End Plate	4 pcs (2 ea)	140-Large Fab - Steps - 2 - B4B	✓ S162063
D3560-042	Arm Weldment	2 pcs (1 ea)	140-Large Fab - Steps - 2 - B4B	✓ S168018 ^{IV}
D3560-044	Arm Weldment	2 pcs (1 ea)	140-Large Fab - Steps - 2 - B4B	✓ S168048
MS20600-AD4W4	Rivet	64 Ea (32 ea)	140-Large Fab - Steps - 2 - B4B	✓ S117999

154338
~~315405~~
~~517661~~

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	2	271	0
140-Large Fab - Steps - 2 - B4B	D2734	4	15	0
	D3560-042	2	2	0
	D3560-044	2	2	0
	MS20600-AD4W4	64	4,067	0

Part Specifications

Specifications could not be found.

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D3562-041
Job Sheet 191046



Part No: D3562-041

Job Qty: 2 pcs

Part Name: Step Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 3/27/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV G IPP Rev:A New Issue 06-11-09 JLM IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C
ECN1048 07-12-18 DD verified by:ec IPP Rev:D 08-07-28 add chemical conversion coat DD ver:EC IPP
REV:E 13.06.03 PER DWG REV.F DD VERF:JLM IPP REV:F 16.06.23 AS PER DWG REV.G DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	2 pcs	3/27/19		0.00	2.96	Large Fab - 1		SLH
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 5	2 pcs	3/27/19		0.00	0.00	Large Fab - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 7		
							QC 5 - 8		
							QC 5 - 9		
							QC 5 - 11		
							QC 5 - 13		
120	Handfinish - 1-1 Chemical-B4B	2 pcs	3/27/19		0.00	0.00	Handfinish - 1		
							Handfinish - 2		
							Handfinish - 3		

				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR 19/04/25
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130	QC 7	2	3/27/19	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 6
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
140	Large Fab - Basket - 2 - B4B	2	3/27/19	0.00 4.50	Large Fab - 1 - B4B
		pcs			Large Fab - 10 - B4B
					Large Fab - 2 - B4B

					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	DAS
					Large Fab - 6 - B4B	43
					Large Fab - 7 - B4B	9-89
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
150 QC 5	2 pcs	3/27/19	0.00 0.00		QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	DAS
					QC 5 - 3	24
					QC 5 - 42	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
160 Large Fab - Steps - 2 - B4B	2 pcs	3/27/19	0.00 2.96		Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	DAS
					Large Fab - 6 - B4B	43
					Large Fab - 7 - B4B	9-89
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
170 QC 10	2 pcs	3/27/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	DAS
					QC 10 - 43	24
					QC 10 - 50	9-89
					QC 10 - 58	
					QC 10 - 9	
					QC 5 - 10	
180 QC 5	2 pcs	3/27/19	0.00 0.00		QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	DAS
					QC 5 - 22	24
					QC 5 - 24	9-89
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
190 Handfinish - 1-2- Chemical-	2	3/27/19	0.00 0.46		Handfinish - 1 - 1 - B4B	

B4B

pcs

Handfinish - 1 - 2 - B4B
 Handfinish - 1 - 3 - B4B
 Handfinish - 1 - 4 - B4B
 Handfinish - 1 - 5 - B4B
 Handfinish - 1 - 6 - B4B
 Handfinish - 1 - 7 - B4B
 Handfinish - 1 - 8 - B4B
 Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 - B4B

D.R.19/05/02

Handfinish - 1 - 11 - B4B

Handfinish - 1 - 12 - B4B

Handfinish - 1 - 13 - B4B

Handfinish - 1 - 14 - B4B

Handfinish - 1 - 15 - B4B

Handfinish - 1 - 16 - B4B

Handfinish - 1 - 17 - B4B

Handfinish - 1 - 18 - B4B

Handfinish - 1 - 19 - B4B

Handfinish - 1 - 20 - B4B

Handfinish - 1 - 21 - B4B

Handfinish - 1 - 22 - B4B

200 Powdercoat - 1 White Si(A)-
 B4B *M 151749.*

2
pcs

3/27/19

0.00 0.55

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

B.R. 19-5-6.

210 Handfinish - 3-1- WingWalk-
 B4B

2
pcs

3/27/19

0.00 0.46

Handfinish - 3 - 1 - B4B

Handfinish - 3 - 2 - B4B

Handfinish - 3 - 3 - B4B

Handfinish - 3 - 4 - B4B

Handfinish - 3 - 5 - B4B

M 19-5-7

215 QC 3

2
pcs

3/27/19

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 26

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 6

QC 3 - 68

MAY 10 2019

230 Packaging 3-1 - Stock - B4B	2 pcs	3/27/19	0.00 0.00	QC 3 - 9	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
240 QC 21 - SA	2 pcs	3/27/19	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70		
				QC 21 - SA - 53		

DAS
28
9-89DAS
21
AUG 01 2019

Part Op 100 - (Fabricate per Drwg), 1-Cut D2622 extrusion as per Dwg D3562

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

140 - 1- Transfer drill Rivet holes as per dwg D3562. 2-Touch-up rivet holes with alodine as per dwg d3562 3-Rivet legs using Scotch-Weld as per dwg D3562. *****Ensure to wipe off any excess magnobond ***** A/R Scotch-Weld DP460

Batch: 3152077 EXP DATE: 8-20-2020

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Weld per dwg A/R Aluminum rod Batch: 413033, 1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as per QSI 024. 2-Grind end cap welds flush as per Dwg D3562

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Chemical Conversion Coat per QSI005 4.1)

200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: _____

210 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

215 - (QC3- Inspect Part Finish)

230 - (Identify as per dwg & Stock Location: _____)

240 - (QC21- Final Inspection - Work Order Release)

Fg dock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 pcs (1 ea)	100-Large Fab - Steps - 1	✓ 5130307
D2734	Step End Plate	4 pcs (2 ea)	140-Large Fab - Basket - 2 - B4B	✓ 5128761 → 3x 5142063
D3560-041	Arm Weldment	2 pcs (1 ea)	140-Large Fab - Basket - 2 - B4B	✓ 5151315
D3560-043	Arm Weldment	2 pcs (1 ea)	140-Large Fab - Basket - 2 - B4B	✓ 5151317
MS20600-AD4W4	Rivet	64 Ea (32 ea)	140-Large Fab - Basket - 2 - B4B	✓ 3117999

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	2	271	0
140-Large Fab - Basket - 2 - B4B	D2734	4	15	0
	D3560-041	2	3	0
	D3560-043	2	2	0
	MS20600-AD4W4	64	4,067	0

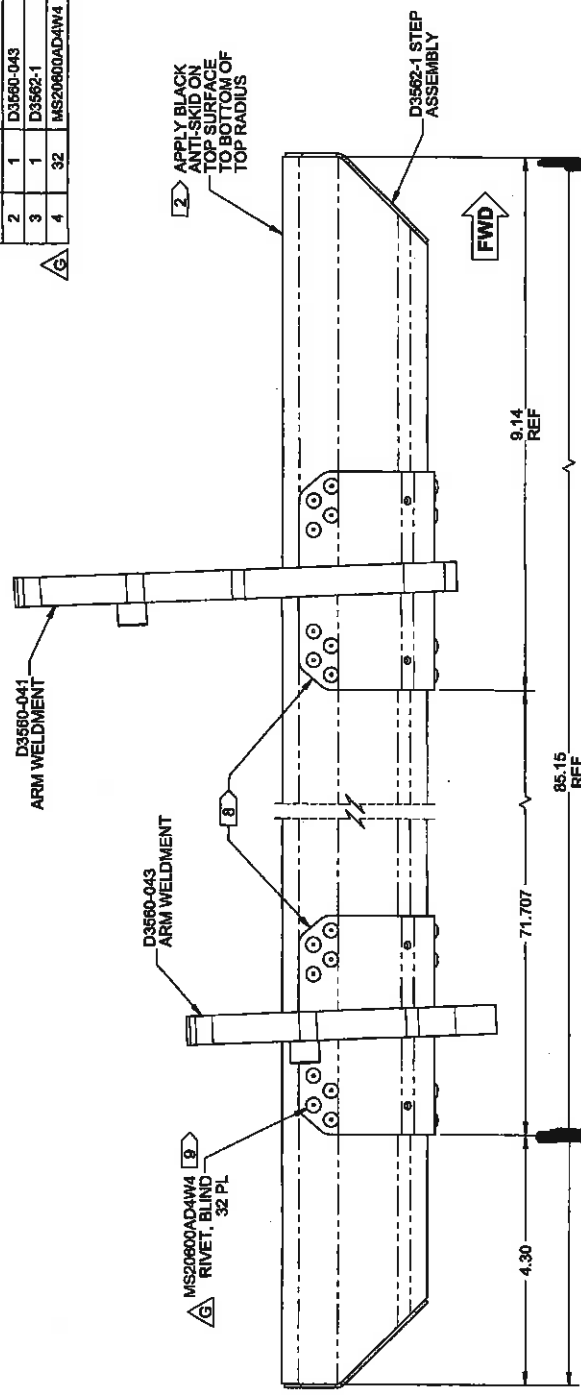
Part Specifications

Specifications could not be found.

Plex 2/20/19 3:55 PM dart.white.jesse

1 2 3 4 5 6 7 8

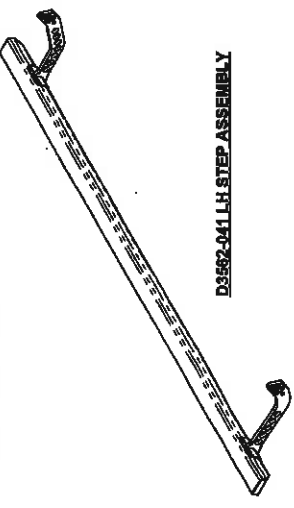
ITEM	QTY	PIN	DESCRIPTION
	X	D3562-041	LH STEP ASSEMBLY
1	1	D3560-041	ARM WELDMENT
2	1	D3560-043	ARM WELDMENT
3	1	D3562-1	STEP ASSEMBLY
4	32	MS20600AD4W4	RIVET, BLIND



RELEASED
2016 JUN 22 07
EOL R-66

MEASURED BEFORE END CAPS WELDED IN PLACE

80.850



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH:
 - i) POWDER COAT ASSEMBLY:
 - ii) GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 8.80 lbs
 - 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
 - 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING

G	MS20600AD4W4 WAS MS20600AD4W5. REV. PART 15-17.	MB	16.04.21
F	REVISED NOTE 8 TO REMOVE MAGNIBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PART 12-24, ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	06.01.11
D	REMOVE D2698 SPACER NOTE: REDRAW IN SOLIDWORKS	DC	07.11.16
C	ADD MAGNIBOND, ADD D2698, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.28
REV.	DESCRIPTION	BY	DATE

DESIGN	CP	DESCRIPTION	DATE
DRAWN	MB	DART AEROSPACE LTD	
CHECKED	ML	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DD	DRAWING NO.	REV. G
APPROVED	WM	D3562	SHEET 1 OF 3
DE APPR.	DS	TITLE	SCALE
DATE	16.04.21	STEP ASSEMBLY	NTS

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